

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024992**Date Inspected:** 16-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Lei/Wen/Shigang/Feng /Wen	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 11

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 144 located on BK012A3-001. Welder is identified as 069866. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 014 located on BK012A2-001. Welder is identified as 066326. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09483.

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This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK011ASD1-001-001, 002, 003, 004, 022, 023, 024, 027

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09486.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK012A2-001-020, 032

BK012ASD1-001-007, 008, 009, 010, 011, 012, 013, 015, 016, 017, 019, 020, 025, 026

BK010A-001-MEP-007, 008, 009, 010, 011, 012, 013, 014, 015, 016, 017, 018, 019, 020, 021

BK009A-001-MEP-007, 008, 009, 010, 011, 012, 013, 014, 015, 016, 017, 018, 019, 020, 021, 201, 202, 203, 204, 205, 206, 207, 208, 209, 210, 211, 212, 213, 214, 215, 216, 217, 218, 219, 220, 221

BK009A9-001-009, 031, 043, 044, 045, 046, 047, 048, 049, 050

BK009A1-001-065, 089, 111, 135

BK009A-001-MEP-051, 052, 053, 054, 055, 056, 057, 058, 059, 060, 061

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09490.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK009A1-001-026, 027, 153, 154, 155, 156, 157, 158, 195, 196, 197, 198, 199, 200, 201, 202, 004, 005, 007, 008, 009, 010, 011, 012, 013, 014, 015, 016, 018, 019, 020, 021, 022, 023, 024, 025

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09486.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK012A2-001-020, 032

BK012ASD1-001-007, 008, 009, 010, 011, 012, 013, 015, 016, 017, 019, 020, 025, 026

BK010A-001-MEP-007, 008, 009, 010, 011, 012, 013, 014, 015, 016, 017, 018, 019, 020, 021

BK009A-001-MEP-007, 008, 009, 010, 011, 012, 013, 014, 015, 016, 017, 018, 019, 020, 021, 201, 202, 203, 204, 205, 206, 207, 208, 209, 210, 211, 212, 213, 214, 215, 216, 217, 218, 219, 220, 221

BK009A9-001-009, 031, 043, 044, 045, 046, 047, 048, 049, 050

BK009A1-001-065, 089, 111, 135

BK009A-001-MEP-051, 052, 053, 054, 055, 056, 057, 058, 059, 060, 061

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No

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09490.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK009A1-001-026, 027, 153, 154, 155, 156, 157, 158, 195, 196, 197, 198, 199, 200, 201, 202, 004, 005, 007, 008, 009, 010, 011, 012, 013, 014, 015, 016, 018, 019, 020, 021, 022, 023, 024, 025

Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09483.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

BK011ASD1-001-001, 002, 003, 004, 022, 023, 024, 027

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt, Scott	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
